

# Work Order ID 71149

Thursday, June 23, 2011 12:36:19 PM



Page 1

Item ID: D3639-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3639	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639 1: Dwg Rev: A 1: Prog Rev: A 1: 2-

2004 .050

Deburr if necessary

B11-6-27



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 11-06-27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo Form as per Dwg D3639	0.00  0.00				(8)			
			SB 11/6/28						
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(8)			
			SB 11/6/28						
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				8			BL 11-6-28

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 71149**

Thursday, June 23, 2011 12:36:19 PM



Page 3

Item ID: D3639-1

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Item Name: Doubler

Start Date: 6/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 *[Signature]* 11/06/28

170

Identify as per dwg & Stock Location: ST244

0.00



Packaging

Memo

0.00

Packaging

JB *[Signature]* 11/06/29

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

- 11/06/29 *[Signature]*11/06/29  
*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 12:36:17 PM

Page 1

Work Order ID: 71149



Parent Item: D3639-1



Parent Item Name: Doubler

Start Date: 6/23/2011

Required Date: 7/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

Purchased

No

100

sf

116.3000

0.239

1.509474



B11-6-07

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

116.3

117684

116.3

117684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	71149
Description: Doubler		Part Number:	D3639-1
Inspection Dwg: D3639	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.626	x		V B02	
Ø0.191	+0.005/-0.001	.192	x		V	
Ø0.098	+0.004/-0.001	.101	2		V	
0.69	+/-0.030	.687	*		V	
1.59	+/-0.030	1.586	2		V	
2.49	+/-0.030	2.491	2		V	
3.39	+/-0.030	3.394	2		V	
3.990	+/-0.010	3.989	x		V	
4.990	+/-0.010	4.990	x		V	
5.19	+/-0.030	5.187	x		V	
6.99	+/-0.030	6.990	2		V	
8.64	+/-0.030	8.645	2		Flow 502	
0.45	+/-0.030	.453	x		V	
0.710	+/-0.010	.714	2		V	
2.000	+/-0.010	1.997	2		V	
2.75	+/-0.030	2.755	2		V	
3.55	+/-0.030	3.549	2		V	
4.00	+/-0.030	4.006	2		V	
2.000	+/-0.010	2.001	x		V	
2.590	+/-0.010	2.591	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-6-07	Date: 11/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

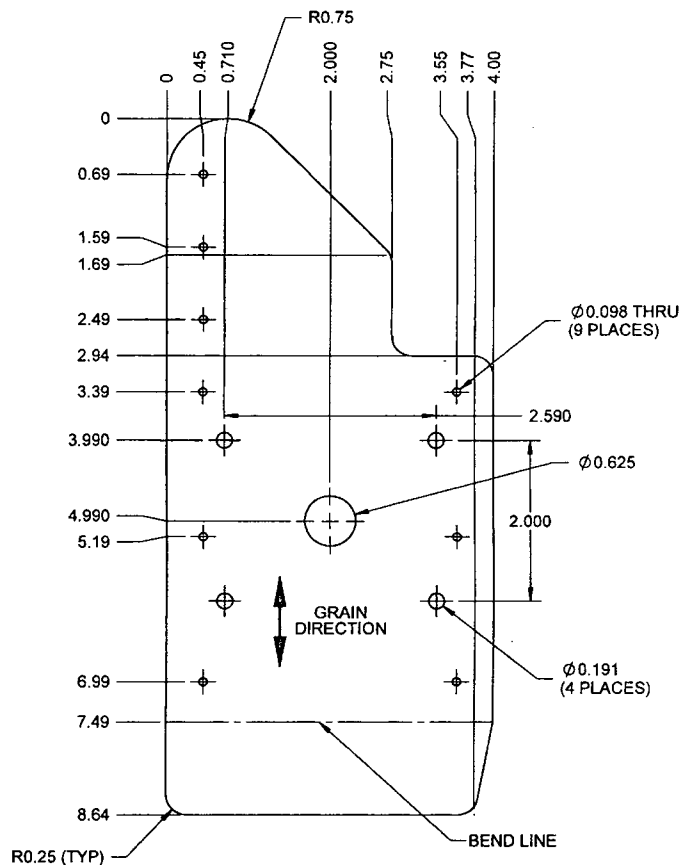
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D

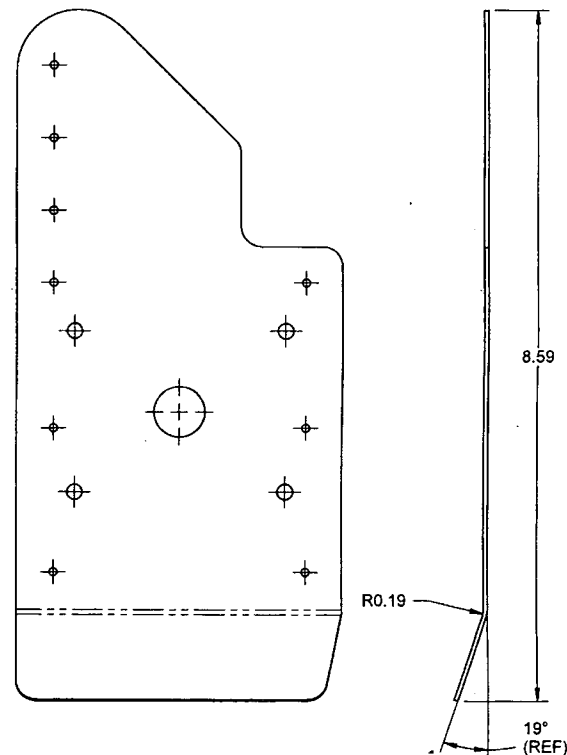
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B

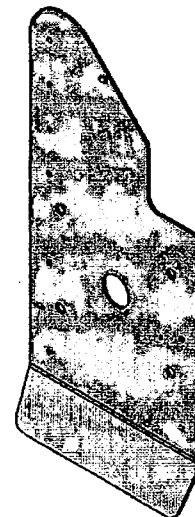
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**D3639-1F FLAT PATTERN**  
**(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**



71149

**RELEASED**  
07.07.27

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.14 lbs

A		NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.		DESCRIPTION		BY	DATE
DESIGN	TS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		REV. A	
DRAWN	LET				
CHECKED	12	DRAWING NO. D3639		SHEET 1 OF 2	
MFG. APPR.	12	TITLE DOUBLER		SCALE 2:3	
DE APPR.	12	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		DATE 07.07.27	
DATE	07.07.27				

8 7 6 5 4 3 2 1

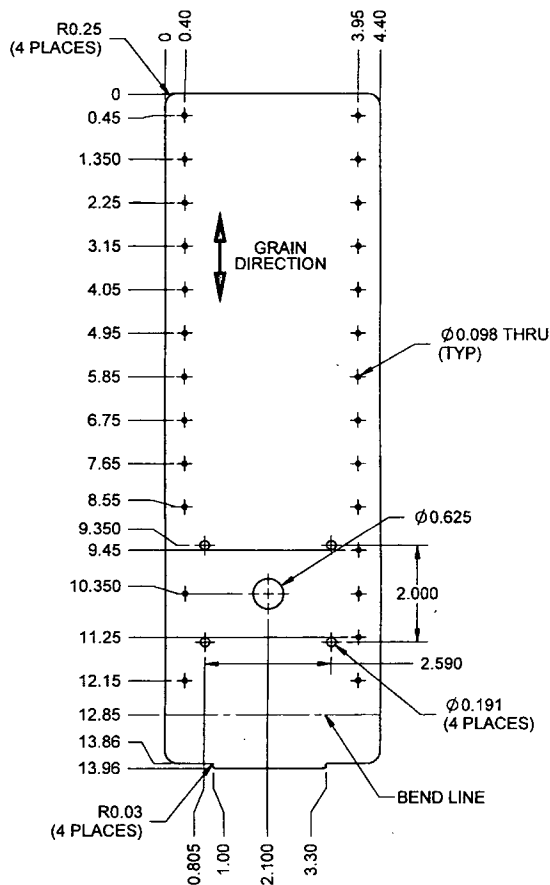
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

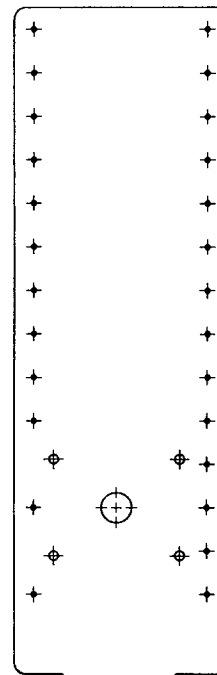
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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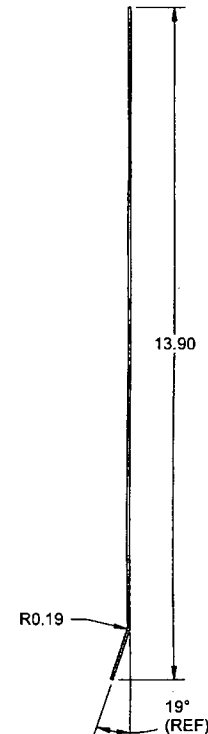
**NOTE:** Date & initial all entries



**D3639-3F FLAT PATTERN  
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER  
(WAS GENEVA P/N G10604-4)  
D3639-4 OPPOSITE  
(WAS GENEVA P/N G10604-5)**



**RELEASED**  
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV.
MFG. APPR.	B	D3639	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	#	DOUBLER	2:
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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